

Date: Wednesday, 17/06/2009 11:32:48 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : THREADED STUD
 Job Number : 48632
 Estimate Number : 11657
 P.O. Number :
 This Issue : 17/06/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 46489
 Part Number : D2829
 Drawing Number : D2829 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 24/06/2009 Qty: 50 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. A 99.07.13 New Issue DM
 Est Rev:B Now Manufactured in House 09-03-14 JLM Verified
 By:EC
 Est Rev:C Changed to 303SS 09-03-16 JLM Verified By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0375 303 Round Bar 0.375"



Comment: Qty.: 0.1050 f(s)/Unit Total : 5.2500 f(s)

303 ROUND BAR 0.375

batch: 1110379

mk 09/06/20

(50)

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA113 & DWG D2829 ,

FOLIO REV: AA

DWG REV: B

2-DEBURR AS REQUIRED

mk 09/06/20

(50)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 09/06/20

(50)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

N.A 09/06/22

(50)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5749

mk 09/06/23

(50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 17/06/2009 11:32:48 AM
User: Linda Lacelle

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: THREADED STUD

Job Number: 48632

Part Number: D2829

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/23 [Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48632
Description: Threaded Stud		Part Number:	D2829
Inspection Dwg: D2829 Rev: B		Page 1 of 1	

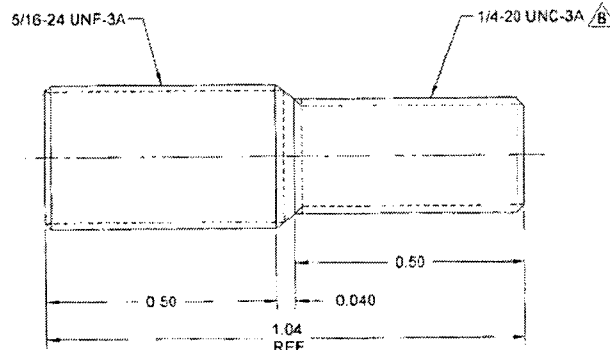
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

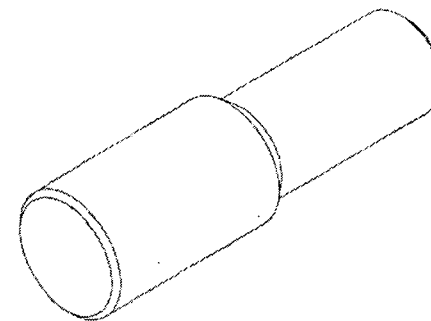
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1.042	—			
0.50	+/-0.030	.486	—			
0.040	+/-0.010	.040	—			
0.50	+/-0.030	.505	—			
1/4-20 UNC-3A	Min: 0.2419 Max: 0.250	.247	—			
5/16-24 UNF-3A	Min: 0.3053 Max: 0.3125	.310	—			
MOW	0.2612-0.2584	.2608	✓			
MOW	0.3363-0.3336	.3353	✓			

Measured by:	ml	Audited by:	L.A	Prototype Approval:	N/A
Date:	09/06/20	Date:	09/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS



D2829 THREADED STUD



4/10/03

RELEASED

NOTES

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND BAR
REF DART SPEC. D304RD DDD
OR
AISI 303 STAINLESS STEEL ROUND BAR
REF DART SPEC. M303RD DDD
- 2) FINISH: NONE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

B		REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT. MATERIAL WAS AISI 4130 (ZIN A5-1), 1/4-20 UNC-3A WAS 1/4-20 UNF-3A (ZIN C5-1). REASON: REVISION OF D2011 FROM REV. F TO REV. G		MB	08.10.03
A		NEW ISSUE		RF	99.05.31
REV	DESCRIPTION			BY	DATE
DESIGN	KE	DART AEROSPACE LTD			
DRAWN		HAWKESBURY, ONTARIO, CANADA			
CHECKED		DRAWING NO.	REV. B		
MFG. APPR.		D2829	SHEET 1 OF 1		
APPROVED		TITLE	SCALE		
DE APPR		THREADED STUD	NTS		
DATE		08.10.03			